

Date: Tuesday, 3/11/2008 7:57:48 AM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|--------------------------------------|--------------|------------------------------------|------------------|-------------------|
| Customer | CU-DAR001 Dart Helicopters Services | Drawing Name | 3" SKID EXTRUSION (NO OUTER RIDGE) | | |
| Job Number | 37756 | | | | |
| Estimate Number | 10054 | | | | |
| P.O. Number | : | Part Number | D26003120 | | |
| This Issue | 3/11/2008 | S.O. No. | D2600 REV D1 | | |
| Prsht Rev. | NC | | Project Number | N/A | |
| First Issue | / / | Type | PURCHASED PARTS | Drawing Revision | D1 |
| Previous Run | 30682 | | Material | : | |
| Written By | : | | Due Date | 4/4/2008 | Qty: 110 Um: Each |
| Checked & Approved By | <i>JL 080311</i> | | | | |
| Comment | Est. D: 02.09.10 Added DSK 066 KJ/RF | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|------------------------|
| 1.0 | PG | PURCHASING |
| | | |
| Comment: PURCHASING Issue P/O: <u>5903</u> <i>C208103/12</i> 110 a) Extrude as per Dwg D2600 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 120" long g) Bon L Canada Inc. tool # 897122 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required | | |
| 2.0 | D26003120P | Extrusion Round 3" 350 |
| | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 110.0000 Each(s) Extradition Round 3" 350 | | |
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | | |
| Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached | | |
| 4.0 | QC6 | DIMENSIONAL CHECK |
| | | |
| Comment: DIMENSIONAL CHECK Inspect dimension per Dwg D2600 Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" SKID EXTRUSION (NO OUTER RIDGE)

Job Number: 37756

Part Number: D26003120

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BACK HAN

BB

08/03/28

NZ

HG

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf

08-03-31

08/04/03

JK

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|----------------------|------------------------|---|------------------------|
| DESIGN <i>DWY</i> | DRAWN BY <i>DWY</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>S</i> | DRAWING NO. D2600 | REV. D SHEET 1 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |
| A | 97.01.21 | NEW ISSUE | |
| B | 97.09.09 | CHANGE MATERIAL SPEC. | |
| C | 98.04.16 | ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO. | |
| D | 98.08.20 | INCREASE MIN. UTS TO 40 KSI | |
| D1 | 01.04.17 | ADD PART NUMBERS & DIE NUMBERS <i>+ GP</i> | |

RELEASED
18.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8 %

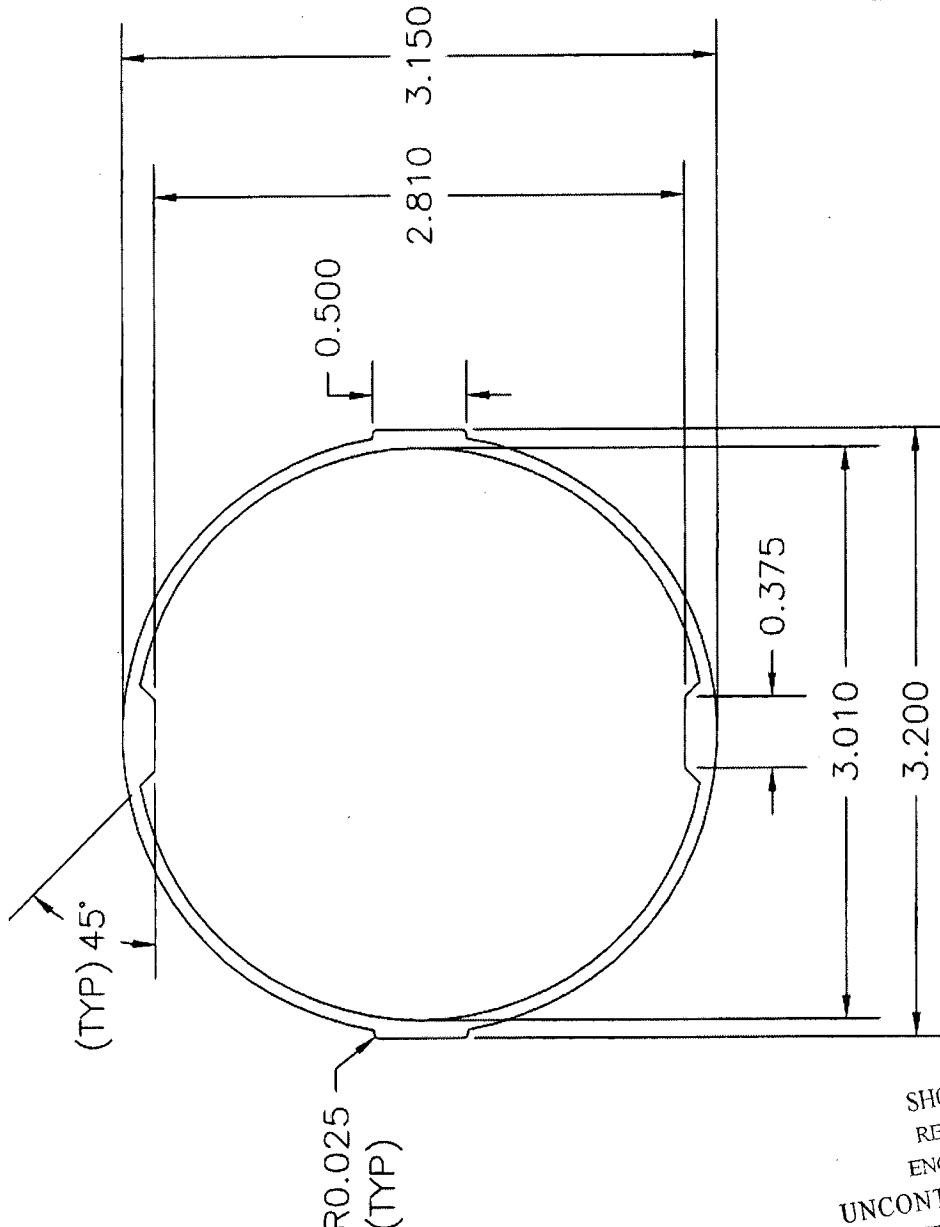
A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
 TO ASTM STANDARD B221 BY AN APPROVED TESTING
 FACILITY TO ENSURE THAT THE BATCH MEETS THE
 ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *37756*

DART

| | | | |
|----------------------|-----------------------|---|--|
| DESIGN <i>DAE</i> | DRAWN BY <i>JH</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>RE</i> | APPROVED <i>JH</i> | DRAWING NO. D2600 | REV. D SHEET 2 OF 5 SCALE 1:1 |
| DATE 98.08.20 | | TITLE EXTRUSION | |

RELEASED
98.8.25 DS

D2600-1

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WITHOUT NOTICE
WORK ORDER
NO. *37756*

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BOWL DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" Long)

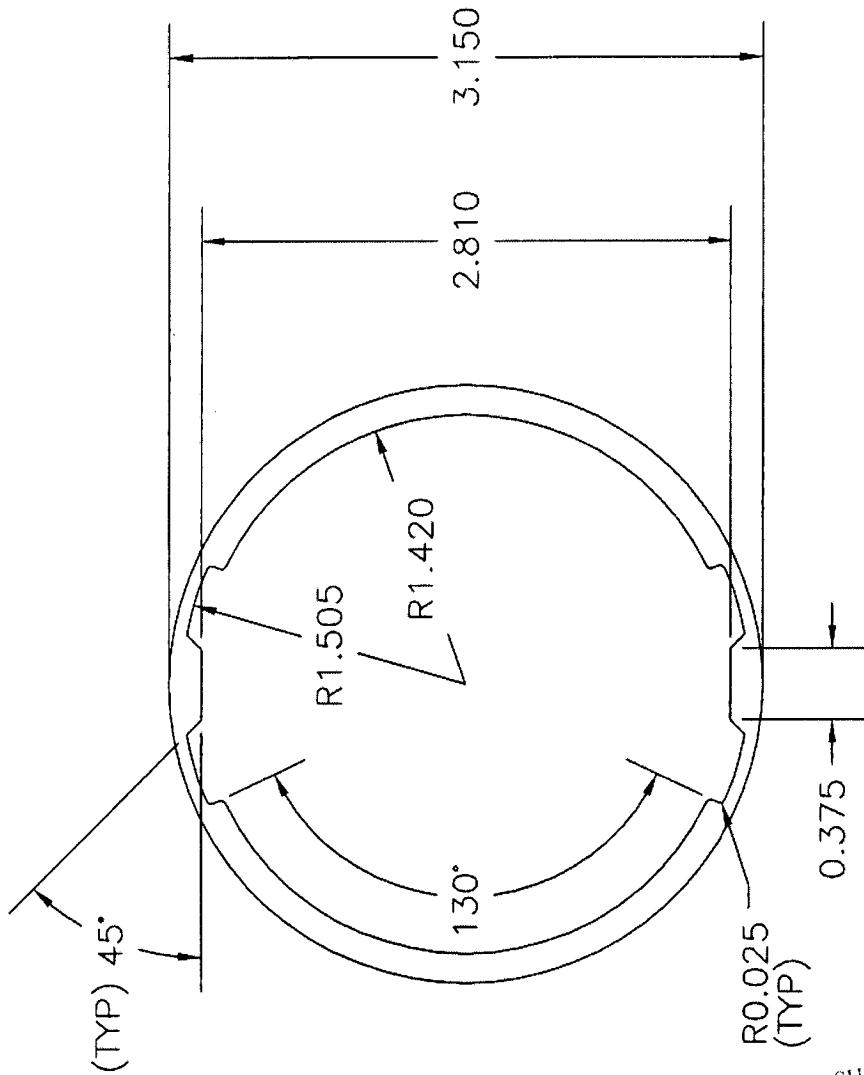


DARTCOPY IS
DENIED

| | | | |
|---------|----------|---|--------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. D |
| DATE | 98.08.20 | TITLE | SCALE |

SHEET 3 OF 5

1:1

RELEASED
98.8.25 DSD2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
or BON L DIE # 897122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (E.G. D2600-3-120 IS 120" long)

WORK ORDER
NO. 37756

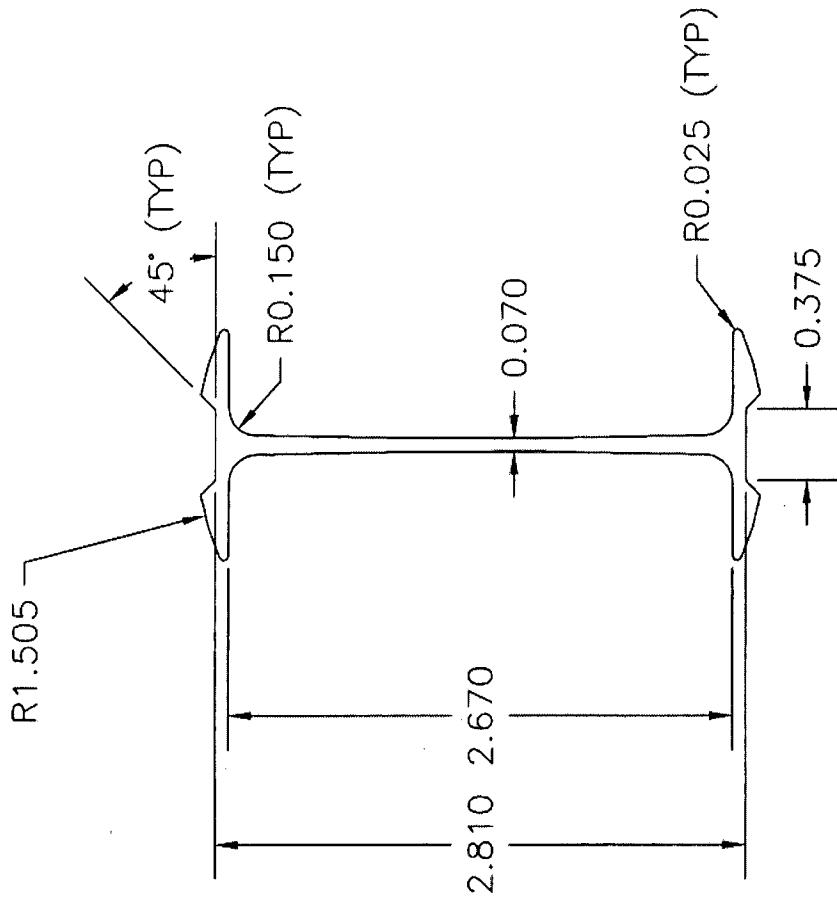




D A C O P Y I S S U E D

| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>MW</i> | DRAWN BY <i>JF</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>JF</i> | DRAWING NO. D2600 | REV. D SHEET 4 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |

RELEASED
(98.8.25 DS)



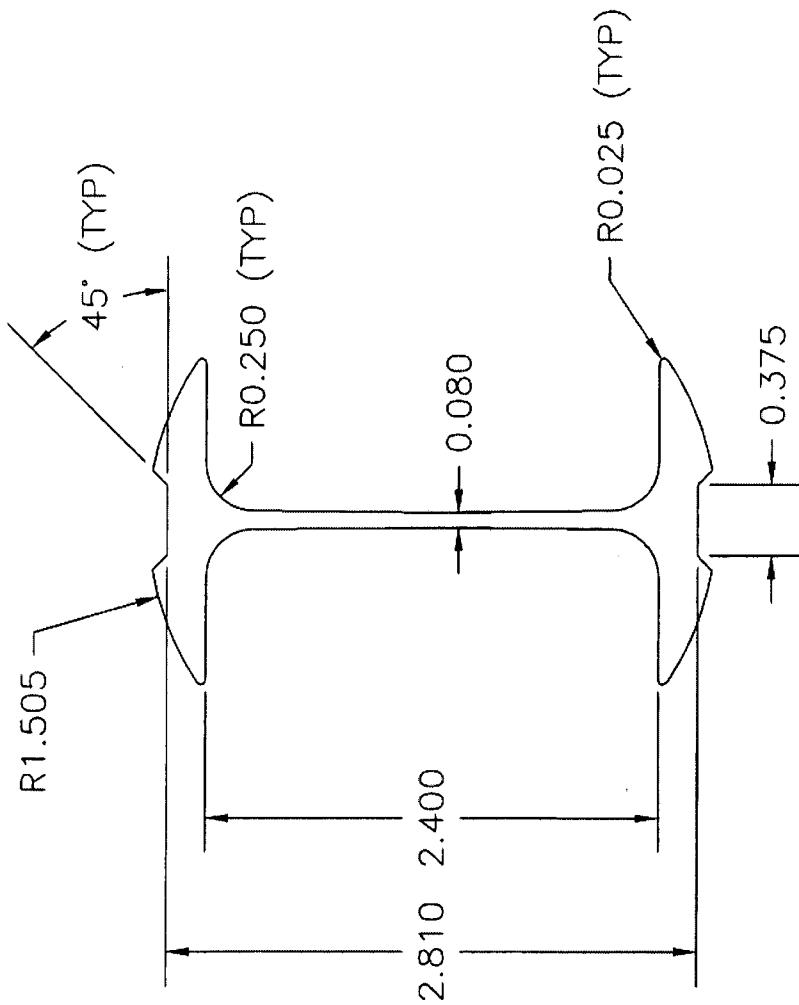
D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART Number is D2600-5-XXX WHERE XXX is CUT LENGTH IN INCHES
(EG. D2600-5-108 is 108" Long)

△
SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO 37750

DART

| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>MH</i> | DRAWN BY <i>AS</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>AS</i> | DRAWING NO. D2600 | REV. D SHEET 5 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |

RELEASED
98.8.25 DSD2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(E.G. D2600-7-125 IS 125" LONG)

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37756*





Canada

ACCT# 00046024

| | | |
|--|--|--|
| SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN | | SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN |
| PHONE 613-632-5200 | | PHONE 613-632-5200 |

INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

TERMS / FREIGHT
O / P

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

| | |
|-----------------------------|---------------------------|
| MANIFEST DATE 03-24-08 | MANIFEST NUMBER 638116 |
| SALES ORDER NUMBER 27644 | SALES REP |

CREDIT REP
HAMBROOK, PAU
905-508-3250

| | | | | |
|-----------------|-------------------------|-------------------|---|--|
| LOCATION PIC | TRAILER NUMBER 57369 | SALESMAN 59358 | FIELD SALES REP Kutter A 450-435-6551 | CUST SERVICE REP Burton D 905-427-2227 |
|-----------------|-------------------------|-------------------|---|--|

BILL OF LADING NUMBER
08375845

| ITEM NO. | ORIGINAL ORDER QUANTITY | UNIT | PREVIOUS SHIPPED QUANTITY | MFG. PART NUMBER | ALLOY & TEMPER | | FINISH DESCRIPTION | | THIS SHIPMENT | | | UNIT | QUANTITY DUE | |
|----------|-------------------------|---------|---------------------------|-----------------------------|-------------------------------------|--|---|--|---------------|-------------------|----------------------|-------------------------|--------------|--|
| | | | | | LENGTH | | FABRICATION DESCRIPTION | | NBR OF PKGS | GROSS POUNDS | NET QUANTITY | | | |
| | | | | CUSTOMER PART NUMBER | CUTTING TOLERANCE | | SHIPPING TOLERANCE | | | | | | | |
| 01 | 110 | KG M PC | 0 0 0 | DAA-897122-1 D2600-3-120 | 6061 /T6 120" +3/16 " -0 " | | MILL CERTIFICATE OF COMP (+015-015,0126-0093) | | 3 | 858 | 837 356.62 117 | KG M PC | 0 0 0 | |
| | | | | LOT/TKT DETAIL: | | | 27644010 / 266162 27644010 / 266163 27644010 / 266164 | | 1 1 1 | 286 286 286 | 279 279 279 | 39 PC 39 PC 39 PC | 117 | |

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

| | | | |
|--------|-----|----------------------|---------|
| 3 | 858 | 837 356.62 117 | KG M PC |
| TOTALS | | | |



CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

| Cast Date | Cert No. | Sales Order | Page |
|-----------|----------|-------------|---------|
| 03/24/08 | 175080 | 27644 | 1 |
| Cust PO | B/L No. | Lot | Date |
| 5903 | 08375845 | 27644010 | 3/24/08 |

| Ship To | Ship To |
|--|--|
| DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 | DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 |

| Item No. | Part No. | Item Description | Cust Part |
|---------------|-------------------------------|-------------------|-------------|
| 1.000 | DAA-897122-1 | 120" Mill 6061 T6 | D2600-3-120 |
| Gross Weight: | 858 KGS | | |
| Net Wtgy | 837 KG | 117 PC | 357 M |
| Specification | AMS-QQ-A-200/8 & ASTM B221-06 | | |
| Die Desc: | | | |

Mechanical Tests:

| Test No. | Tensile MPA / KSI | Yield MPA / KSI | %Elongation | Conductivity | Bend Drift | HREW |
|----------|-------------------|-----------------|-------------|--------------|------------|------|
| 1 | 285.4 / 41.4 | 259.8 / 37.7 | 13.5 | .0 | 94 | |

Chemical Analysis:

SI FE CU MN MG CR ZN TI

| | | | | | | | |
|-----|-----|-----|-----|-----|-----|-----|-----|
| .66 | .26 | .26 | .11 | .87 | .06 | .06 | .02 |
| .61 | .24 | .27 | .06 | .89 | .06 | .05 | .02 |

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc